

## CLAIMS

What is claimed is:

- 5 1. A composition comprising, as pre-mixture ingredients,
  - (i) at least one free radical curable component;
  - (ii) at least one cationically curable component;
  - (iii) at least one free radical photoinitiator selected from the group consisting of benzophenones; and
  - 10 (iv) at least one other free radical photoinitiator not selected from the group consisting of benzophenones.
2. The composition according to claim 1, wherein said at least one photoinitiator is benzophenone.
- 15 3. The composition according to any one of claims 1-2, wherein said at least one other photoinitiator is 1-hydroxycyclohexyl phenyl ketone.
4. The composition according to any one of claims 1-3, wherein the weight ratio of said at least one photoinitiator to said at least one other photoinitiator is less than 0.50.
- 20 5. The composition according to any one of claims 1-3, wherein the weight ratio of said at least one photoinitiator to said at least one other photoinitiator is less than 0.05.
- 25 6. The composition according to any one of claims 1-5, wherein the weight ratio of said at least one photoinitiator to said at least one other photoinitiator is at least 0.01.
7. The composition according to any one of claims 1-6, wherein said at least one cationically curable component includes a cycloaliphatic diepoxide.

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8. The composition according to any one of claims 1-7, wherein said at least one cationically curable component includes an oxetane compound.
9. The composition according to any one of claims 1-8, wherein said at least one free radical curable component includes a (meth)acrylate functional pentaerythritol derivative.
10. The composition according to claim 9, wherein said pentaerythritol derivative is monohydroxy dipentaerythriol pentaacrylate.
11. The composition according to any one of claims 1-10, wherein said at least one free radical curable component includes a (meth)acrylate-functional neopentylglycol derivative.
12. The composition according to any one of claims 1-11, wherein said composition comprises a polyol.
13. The composition according to claim 12, wherein said polyol is a polyether polyol.
14. The composition according to claim 12, wherein said polyol is a polyester polyol.
15. The composition according to any one of claims 12-14, wherein said hydroxy-functional component has a molecular weight in the range of 200-2500 g/mol.
16. The composition according to any one of claims 1-15, wherein said composition comprises less than 1.5wt%, relative to the total composition, of said at least one photoinitiator.
17. The composition according to any one of claims 1-15, wherein said composition comprises less than 0.5wt%, relative to the total composition, of said at least one photoinitiator.
18. The composition according to any one of claims 1-17, wherein said composition comprises, relative to the total weight of said composition, 5-35 wt% of said at least one free radical curable component.

19. The composition according to any one of claims 1-18, wherein said composition comprises, relative to the total weight of said composition, 45-90 wt% of said at least one cationically curable component.
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20. The composition according to any one of claims 1-19, wherein said composition comprises at least 5 wt% of a hydroxy-functional component.
21. The composition according to claim 20, wherein said hydroxy-functional component is
- 10 absent epoxy groups, oxetane groups, and free radical curable groups.
22. The composition according to any one of claims 1-21, wherein said composition has an E10 number of less than 60 mJ/cm<sup>2</sup>.
- 15 23. A composition comprising, as pre-mixture ingredients,
- (i) at least one free radical curable component; and
- (ii) 0.01 to less than 0.50 wt% of a free radical photoinitiator selected from the group consisting of benzophenones.
- 20 24. A process for forming a three-dimensional object comprising rapid prototyping the composition according to any one of claims 1-23.
25. An article obtainable by the process of claim 24.
- 25 26. A process for improving the color stability of an article formed at least in part by curing a composition, wherein the process comprises including a photoinitiator selected from the group of benzophenones in the composition prior to cure.
27. The process of claim 26, wherein said composition comprises at least one other
- 30 photoinitiator not selected from the group consisting of benzophenones.